

Date: Wednesday, 25/06/2008 12:00:03 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP SPACER		
Job Number	: 40087B			Part Number	: D2322		
Estimate Number	: 10354			Drawing Number	: D2322 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 25/06/2008 S.O. No. :			Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 07/07/2008 Qty: 12 Um: Each		
Previous Run	: 37925B						
Written By	:						
Checked & Approved By	: <u>JUL 08.6.25</u>						
Comment	: Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now on Waterjet 06-07-03 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S040	2024-T3 .040 sheet	
		Comment: Qty.: 0.2132 sf(s)/Unit Total : 2.5578 sf(s) Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick (M2024T3S.040) Identify as D2322 Batch: <u>107572</u> FB 8-7-3	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2322 Dwg Rev: <u>C</u> FB 8-7-3 Prog Rev: <u>C</u>	
		2-Deburr if necessary FB 8-7-3	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		HB 8-7-3	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		S 08/07/08 NC	
		Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Form as per Dwg D2322	
		SB 08/07/08	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



S 08/07/08 x/100

Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



14

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



18/08/08 14

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

SYLVE

PC 08/08 14

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/07/10 14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



UMF 08-07-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	400878
Description: Step Spacer	Part Number:	D2322
Inspection Dwg: D2322	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: B	Audited by: <u> </u>	Prototype Approval: N/A
Date: 8-7-3	Date: 08/07/03	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue	P/O D2582	KJ/JLM 

DART

DESIGN DRAWN BY DART AEROSPACE LTD
DW *CP* HAWKESBURY, ONTARIO, CANADA
CHECKED APPROVED DRAWING NO. REV. C
KE *MM* D2322 SHEET 1 OF 1
DATE 98.09.29 TIME
TIME 1:2
SCALE

A	94.10.14	NEW ISSUE
C	98.09.29	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER NCR 001

RELEASED**UNDER REVIEW**

10/03/98 QP

DESIGN OK, BUT CHECK WITH
ENGINEERING BEFORE MANUFACTURE

OK by *MM*

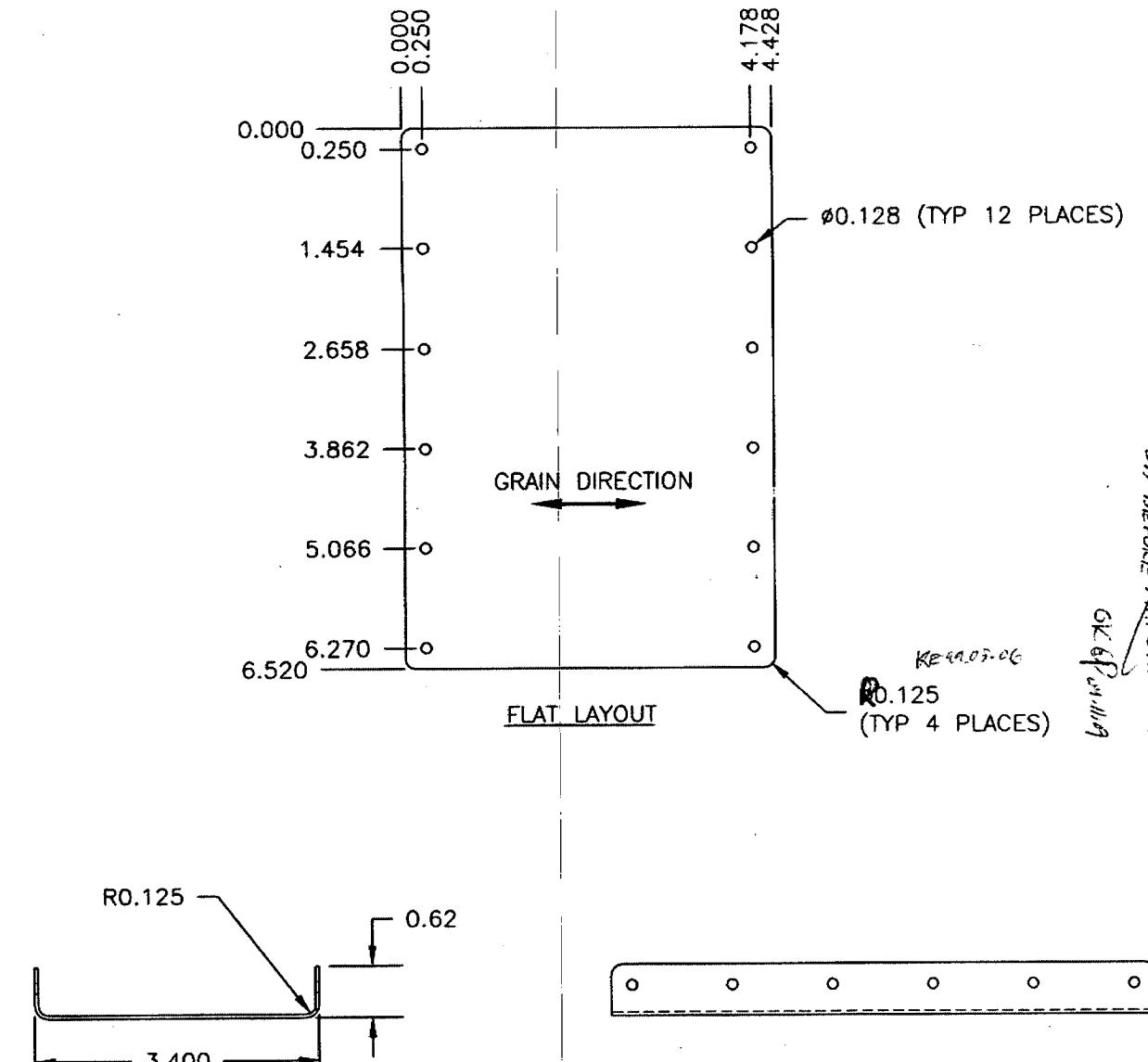
Ø0.128 (TYP 12 PLACES)

Ø0.125 (TYP 4 PLACES)

KE 99.09.06

GRAIN DIRECTION

FLAT LAYOUT



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *100813*